Work Orde Friday, Februar				*973	349*				(et)	27	M	Page 1
Revision ID:	D3876-7 Protector - Af	ft Wall		Accept	*N90))) ()	1100)*	Setup	Start Stop	173	S1* S2*
Start Date: Required Date: Reference:	2/15/2013 2/22/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust It						ı V.	
Approvals:		an: Myc				Date:			Run	Start Stop	171	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool l	ID Tool #	Plan Code	Accep Qty	t Rejo		Reject Number	Insp.
Draw Nbr	Rev	vision Nbr				**						— -
D3876	A											
*100 *100*		FLOW WATER JET		0.00				6		<i></i>		JMB-2-20
Waterjet FLOW CNC Waterje	et ·	Memo 1-Cut as per Dwg Rev:_ Prog Rev:_ 2- Deburr if	<u></u> Ar	0.00					--	<u>-</u>		<u>,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,</u>
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00				_				
110 QC Quality Control		Memo		0.00				<i>6</i>		<u></u>		Jm13-2-20
120		QC8- Inspect parts - seco	and check	0.00								
120 QC Quality Control		Memo		0.00 13 2	<i>31</i>			6				

NCR:															
												QA Closed:	Date:		
Nork Orde	er:						DISPOSITION AGAINST D				AGAINST DE	EPARTMENT/PROCESS			
Part N	No.						Rework Scrap		Skid-tube Crosstube Machining Small Fab			-1	Water Jet	Engineering Quality Quality	
NCR No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other			
Root					Desc	rip	tion of work order update	Ī	nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		01	r Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector	
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		Bending					Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks					Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	Weld	
		Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs					Contamination		Mainte	enance		Part Moved			
		Heat Trea	it		Γ		Countersink		Mislabe	eled		Positioned V	Vrong	_	
	Inspection Strip in Tube Cut Too Short				Cut Too Short		Misread	i		Power Loss/	Surge	Other			
	Ripples in Bend Drill Holes						Drill Holes		Offset						
		Torque W	aves in E	xtrusio	n [Drawing		Out of	Calibration					
	Turning Sequence Finish								Out of Sequence						
	Wave/Twist in Tube Folio								Outside Dimensions						

DQA: Date:

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140

QC21- Final Inspection - Work Order Release

0.00

0.00

OC

Memo

Quality Control

13-2-25

Insp.

Stamp

Page 2

NCR:	Yes	/	No	
		,		

DQA: Date:

NCR:	'es	/ No				WORK ORDER NON-	COI	NFORN	MANCE / UPL	JAIL	QA Closed:	Date:	
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Nork Orde	er:					DISPOSITION				AGAINST DI	PARTMENT/	PROCESS	
Part N	lo.					Rework Scrap	יז	Skid-tube Machining	Crosstube Small Fab	1	Water Jet	Engineering Quality	
NCR No.					Use-as-is Work Order Update		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other		
Root					Descr	ription of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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		Centre No	ot Concer	ntric to (^{5/5} -	BOM/Route	\vdash	Hardwa			Over/Under	 	Temperature/Cure Weld
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		Crushed/0	Crimpea.		-	Burrs	\vdash	Mainte	ions Incomplete/U	Unclear	Part Moved	rssilig	
		Cuffs			-	Countarial	-	Mislabe		<u> </u>	Positioned V	Vrong	
	Heat Treat Countersink				-	Misread		<u></u>	Power Loss/		Other		
	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes					\vdash	Offset	ı	L.	Trower ross/	Juige _	Totalet	
	Torque Waves in Extrusion Drawing							Out of Calibration					
!		Turning S			''	Finish	Out of Sequence						
		Wave/Tw				Folio	Out or sequence Outside Dimensions						
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Picklist Print

Friday, February 15, 2013 2:56:35 PM

Work Order ID:

97349

Parent Item:

D3876-7

Parent Item Name:

Protector - Aft Wall

Start Date: 2/15/2013

Required Date: 2/22/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Replacement Mfg/ Bin

Item Name Item ID Purch Item No

Primary Last Location Location

Route Seq ID

Unit of Measure Hand

Qty on

Qty per Kit Total Qty

Qty Date Issued Issued

Status

Page 1

MLEXS.125-F60029-04

GE PLASTICS LEXAN SHEET

Purchased

100

sf 0.0000 2.49

-15.726316 ZO

JMB-2-20

124655

124655

											DQA:	Date:	₽	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORN	ANCE / UP	DATE				
		,	-:-							_	QA Closed:	Date:		
Work Ord	er.					DISPOSITION				AGAINST DEPARTMENT/PROCESS				
Part No.						Rework Scrap		ľ	Skid-tube Crosstube Machining Small Fab		Water Jet Prod. Eng. Coor.		Engineering Quality Other	
NCR No.					Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other		
Root		· ·			Descri	ption of work order update	1	Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	. (or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling														
Operator														
Material			}	:										
Setup														
Other														
Process														
Supplier														
Training														
Unapproved														
							AUI	T CATE	GORY					
Landi	ing (Gear				General		_			_		7	
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
	Centre Not Concentric to O/S					BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks					Broken/Damaged		Inspecti	on Incomplete	<u></u>	Part Incorre	ct	Weld	
Crushed/Crimped.						Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs					Contamination		Mainte	nance		Part Moved			
	Heat Treat					Countersink		Mislabe	eled		Positioned \	Wrong	_	
	Inspection Strip in Tube					Cut Too Short		Misread	i .		Power Loss,	'Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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DART AEROSPACE LTD	Work Order:	97349
Description: Protector – Aft Wall	Part Number:	D3876-7
Inspection Dwg: D3876 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototyp	е
	I II 3t Altiolo		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.63	+/-0.030	1,63"	_		V	Thmoi
8.50	+/-0.030	8,50"	_		V	Productors
15.37	+/-0.030	15.37	~		T	Jamolo .
17.00	+/-0.030	17.00"	-		T	
0.27	+/-0.030	0.27"	_		v	,
1.90	+/-0.030	1.90°	-		V	
18.24	+/-0.030	18.247	-		T	
19.87	+/-0.030	19.87"	-		T	
20.14	+/-0.030	20.14"	_		T	
0.125	+/-0.010	0.126"			V	
					· · · · · · · · · · · · · · · · · · ·	
						•

Measured by: Jm	Audited by: 15	Prototype Approval:	N/A
Date: 13218	Date: 1301	Date:	N/A

Rev	Date	Change	Revised b	, , , , p
Α	09.06.22	New Issue	KJ \$\$	- 44
			77	

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	ON	NFORM	MANCE / UPD	DATE	QA Closed:	 Date:	
							DISPOSITION				AGAINST DE			
Work Ord	er: ˌ						n	,				1	Water Jet	Engineering
Part No.						Rework Scrap Use-as-is		r	Skid-tube Machining noforming	Crosstube Small Fab Finishing	Prod. Eng. Coor. Rec/Store/Packaging		Quality Other	
NCR No.						Work Order Update]		Large Fab	Composite		Supplier		
Root					Des	crip	otion of work order update	Ī	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		С	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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	Bending Centre Not Concentric to O/S Cracks						Bend BOM/Route Broken/Damaged		Grain Hardwa Inspect	re on Incomplete		Ovalized Over/Under tolerance Part Incorrect		Pressure/Forced Temperature/Cure Weld
							Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
					Contamination		Mainte	nance		Part Moved				
	Heat Treat						Countersink		Mislabe	led		Positioned V	Wrong	
	Inspection Strip in Tube Cut Too Short						Cut Too Short		Misread	i		Power Loss/	'Surge	Other
	Ripples in Bend Drill Holes						Drill Holes		Offset					
		Torque W	aves in E	Extrusion			Drawing		Out of	Calibration				
	Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Out of Sequence													

Outside Dimensions

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Wave/Twist in Tube

Folio

